Work Order ID 75054 October-17-11 10:39:49 AM			*750	154*						Page 1	
Item ID: Revision ID:	D3417-7			Accept	*N900	04 0	100) * s	Setup Star	1	IS1*
Item Name: Start Date:	Washer 17/10/2011	Start Qty: 20.0	° *20*		Cust Item I	D.			510	ν * Ν	IS2*
Required Date:		Req'd Qty: 20.0			Customer:	D;					
Approvals:	Process Pla	an: <u> </u>	Date: 1110 13	Tooling:	Da	ite:		F	Run Stai		R1*
	QC:		Date:	SPC (Y/N):	Da	ite:			Sto	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr									
D3417	Rev	/ F									
*100 *100* Doosan Doosan Lathe		Hardinge CNC LATH Memo 1-Turn as 2-Deburr	./	0.00 0.00 & Dwg D3417 Rev:	<u> </u> 1131016	d >		20	þ		
110		QC2- Inspect parts off	machine FAI/FAIB	0.00							
110 QC Quality Control		Memo		0.00	101016		. •	20)_	_		
120		QC8- Inspect parts - so	econd check	0.00				.a	/		
120 QC Quality Control		Мето	· ·	0.00 B.S	11/11/16			20_	Ø		

Dart Aerospace Ltd WORK ORDER CHANGES W/O: **Approval Approval** STEP DATE By PROCEDURE CHANGE Date Qtv Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: _____ Fault Category: ______ NCR: Yes No DQA: ____ Date: _____ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B Verification **Description of NC Approval Approval** DATE **STEP** Sign & **Action Description** Initial Section A Section C Chief Eng QC Inspector Chief Eng Chief Eng Date

NOTE: Date & initial all entries

75054 Page 2 October-17-11 10:39:49 AM Item ID: D3417-7 Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: Washer **Start Qty: 20.00 Start Date:** 17/10/2011 **Cust Item ID: Required Date: 28/10/2011** Req'd Qty: 20.00 **Customer:** Reference: Run Start **Process Plan:** Date: **Tooling:** Approvals: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp Identify as per dwg & Stock Location 130 0.00 *130* Packaging 0.00 Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00 *140*

QC Quality Control

Memo

0.00

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W/O:			WO	RK ORDER CHANG	ES		· <u> </u>		· · ·
DATE	STEP	PR	OCEDURE CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								1,000,000,000	
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Disposition		QA: N/C C	losed:		Date: _	
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NC	₹)			
DATE	STEP	Description of NC	ļ	Corrective Action Section			cation	Approval	Approval
	O I E I	Section A	Initial Chief Eng	Action Description Chief Eng	Sign a	Secti	on C	Chief Eng	QC Inspector
								:	
									
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NOTE: Date & initial all entries

· Picklist Print

October-17-11 10:39:54 AM

Work Order ID: 75054

75054

D3417-7 Parent Item:

Parent Item Name: Washer

D3417-7

Start Date: 17/10/2011

Required Date: 28/10/2011

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.2500		Purchased	No			100	f	30.6390	0.0296	0.623158			,
MDFI RII	VR1 250)O							**	< >	_ h	1/1/1	6

DELRIN ROUND BAR 1.25"

Loc Qty	Loc Code
30.639	
6.639	
24	
	30.639 6.639

Dart	Aeros	pace	Ltd
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W/O:			W	ORK ORDER CHANG	GES			_		
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	1	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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						<u> </u>				
Part No	•	PAR #:	Fault Cate	gory:	NCR: Ye	es No	DQA	۸:	_ Date: _	
	R	esolution:	Dispositio	n:	QA: N/C	Clos	ed:		Date:	
NCR:			WORK ORD	ER NON-CONFORM	IANCE (N	CR)				
DATE	OTED	Description of NC		·	ction B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Section		Chief Eng	QC Inspector
	1	1	1		li	ı				1

NOTE: Date & initial all entries

DART AEROSPACE LTI		Work Order:	75054
Description: Wasla		Part Number:	13417-7
Inspection Dwg:	Rev: /-		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

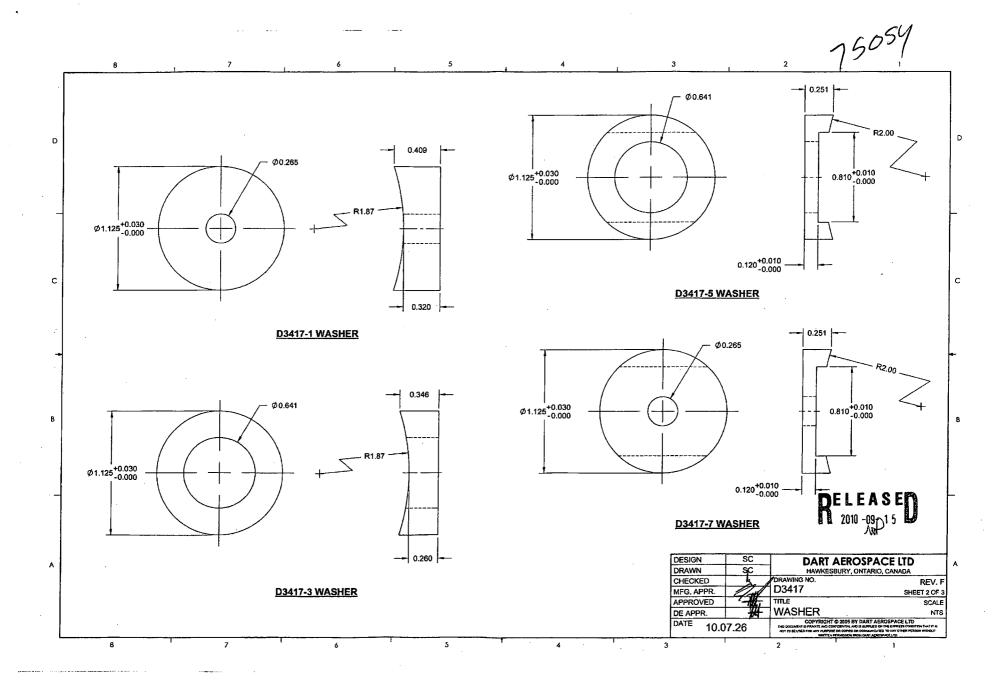
I INOT ARTICLE IROT COTTON CITEOREIO									
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments			
91.125 9,265	1.070 000	1,140							
9,263	000 000	268							
-870	L.010	.815							
-251	I.010	-252							
-251 -120	1.010 1.010 000	_/23							
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Measured by:	SD	Audited by:	H.A		Preliminary Approval:	
Date:	11/1/16	Date:	11/11/16		Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

SHOP COPY RETURN TO

ENGINEERING 4 UNCONTROLLED COPS SUBJECT TO AMENDMEN' WITHOUT NOTICE WORK ORDER D NO 25054 С **D3417-1 WASHER D3417-7 WASHER D3417-3 WASHER D3417-5 WASHER** ADD D3417-9 (ZN B5-3) 10.07.26 ADD D3417-7 (ZN A2-2) 09.06.30 ADD -5 WASHER (ZN B2-1, B2-2); REFORMAT TO "B" SIZE & UPDATE TO CURRENT STANDARDS; REASON: INSTALLATION OF NEW TOW RING NOTES:
1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL, ROD
REF DART SPEC M-DELRIN-R
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR
REF DART SPEC M-DELRIN-B
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET
REF DART SPEC M-DELRIN-S D 08.07.08 С REMOVE CBORE, WIDEN PH 05.06.30 CHANGE TO ROUND WASHER В 05.06.10 NEW ISSUE A PH 05.03.31 REV. DESCRIPTION 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D3417-1, 0.020 lbs
D3417-5, 0.010 lbs
D3417-7, 0.010 lbs
D3417-9, 0.004 lbs BY DATE **D3417-9 WASHER** SC DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. D3417 MFG. APPR. SHEET 1 OF APPROVED TITLE SCALE WASHER DE APPR. COPYRIGHT © 2005 BY DART AEROSPACE LTD this bockboth of Prince and Controlling Management and Controlling Management (Management Age and Age a NTS DATE 10.07.26 3 2



0.181 Ø0.641 Ø1.125^{+0.030}_{-0.000} 0.078 D3417-9 WASHER DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO.
D3417 SHEE DESIGN DRAWN CHECKED REV. F MFG. APPR. SHEET 3 OF 3 TITLE APPROVED SCALE DE APPR. 4 DATE 10.07.26 WASHER